

Date: Thursday, 14/05/2009 11:11:37 AM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 47960 <i>42</i>		
Estimate Number	: 12973		
P.O. Number	:	Part Number	: D36461 <i>BK MD 09/05/14</i>
This Issue	: 14/05/2009 S.O. No. :	Drawing Number	: D3646 U/R
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: A
Previous Run	: 47718	Type	: SMALL /MED FAB
Material	:	Material	:
Due Date	: 21/05/2009	Qty:	<i>8</i> Um: Each
Written By	:		
Checked & Approved By	: <i>MF 09-05-14</i>		
Comment	: Est Rev. A new issue 07.07.25 EC verified by:JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 2.0790 f(s)/Unit Total : *20.7900 f(s) 16.632*
Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)

Batch: *17 111704**FF 09-05-19**(8)*

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch to length as per Dwg D3646 & template DT8958

*FF 09-05-19**(8)*

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

*FF 09-05-19**(8)*

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/05/11 (x8)

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

11:00

OVEN TEMPERATURE:

*320°**(x8)**MD**09/05/20*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 14/05/2009 11:11:37 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 47960

Part Number: D36461

Job Number:



Seq. #:

Machine Or Operation:

Description :

FINISH TIME:

11:30

MD

09/05/20

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



UB



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-20

(X8)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



(8X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 229

9/5/21

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/21 MF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

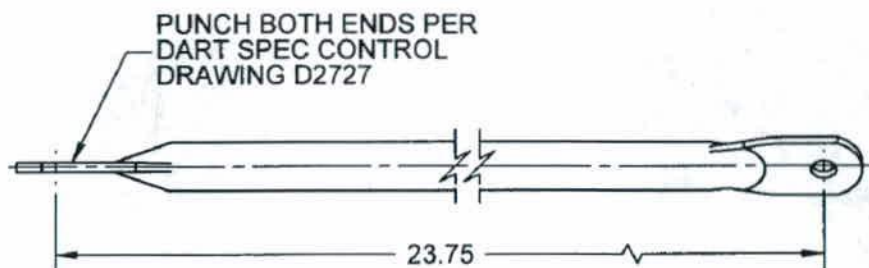
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

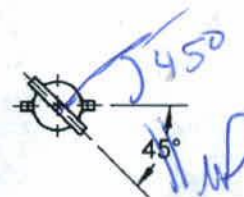
NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3646	REV. A SHEET 1 OF 2
DATE 07.06.06	TITLE ARM		SCALE 1:2
REV A	DATE 07.06.06	DESCRIPTION NEW ISSUE	

RELEASED07.07.11 *[Signature]*

24.55 Tot. Length



#47960

D3646-1 ARM**NOTES:**

- 1) MAKE PER TEMPLATE DT8958
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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